

Date: Thursday, 05/02/2009 3:47:50 PM  
 User: Julie Dawson

## Process Sheet

Split for Qty 2 on order 109-09

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD FLOOR RH  
 Job Number : 45579 -1  
 Estimate Number : 13594  
 P.O. Number :  
 This Issue : 05/02/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D3798042 BX  
 Drawing Number : D3798 REV A  
 Project Number : N/A  
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run :  
 Material :  
 Due Date : 28/02/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : JUD 09.02.06  
 Comment : Est Rev:A 08-09-18 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 9.2334 sf(s)/Unit Total: 36.9335 sf(s)

6061-T6 .050 Sheet

Batch: 110791 HB 9-2-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3798-1

Dwg Rev: A

Prog Rev: A

HB 9-2-27

(4)

2-Deburr if necessary HB 9-2-27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 9-2-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

\*\*\*template D3798-1T1\*\*\*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

\*\*\*template D3798-1T1\*\*\*

09-03-03 (4)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

und

09/03/03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:47:50 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR RH

Job Number: 45579

Part Number: D3798042

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 POWDER COATING POWDER COATING



M 105642



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

(4)

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FL 09/03/04

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

OK 04-03-11 (A)

8.0 D37983 Spacepod Floor Foam



Comment: Qty.: 1.0000 Each(s)/Unit  
Spacepod Floor Foam

Total: 4.0000 Each(s)

B 45726 x2

B 46895 x2

FF 09-03-09

(2)

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install foam as per dwg D3798 using contact cement

batch: M 111090

M 105632

FF 09-03-09

2- trim foam if necessary

FF 09/03/09

PTC

(2)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 02/06/03

(2)

see split

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

8 9/6/03

(2)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion







C 209/06/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

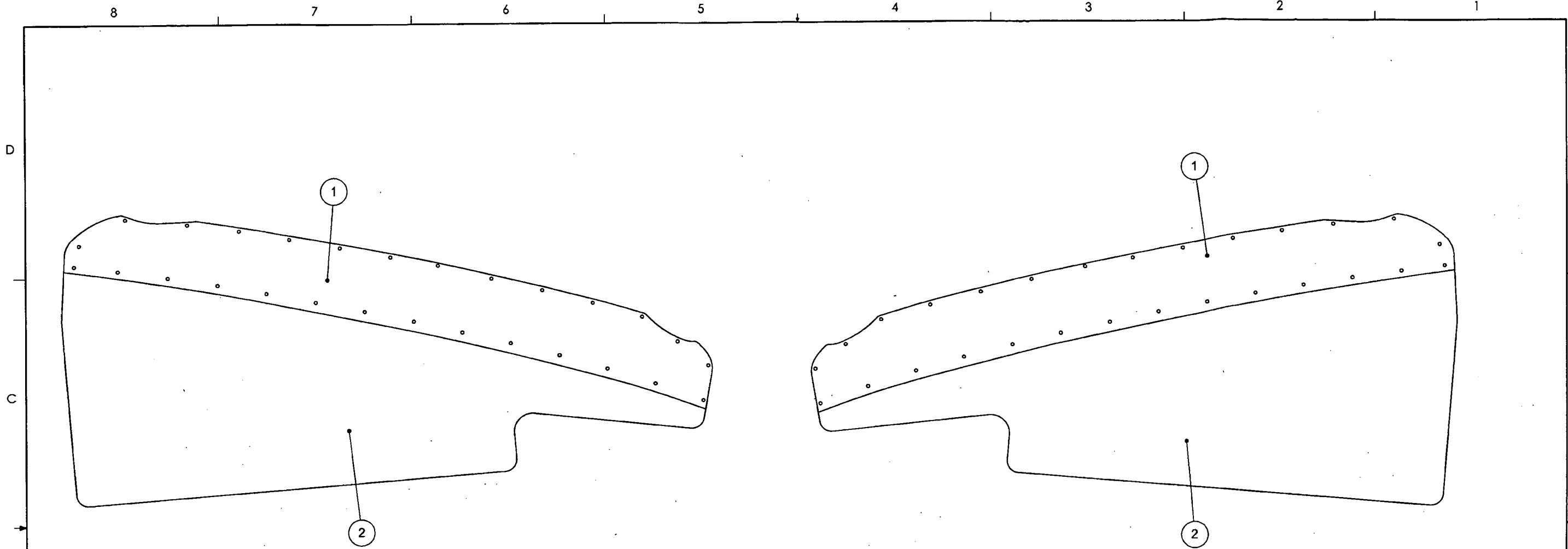
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR) |   |                                 |                |  |   |   |
|----------|------|----------------------------------|---|---------------------------------|----------------|--|---|---|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action Section B   |                                 |                | Verification<br>Section C  | Approval<br>Chief Eng   | Approval<br>QC Inspector  |
|          |      |                                  | Initial<br>Chief Eng  | Action Description<br>Chief Eng | Sign &<br>Date |  |   |   |
| 09-06-23 | 9    | powder was scratched             | <br>09/06/23 | touch up base with<br>Alodine   | IT<br>09-06-23 | <br>09/06/23 | <br>09/06/23 | <br>09/06/23 |
|          |      |                                  |   |                                 |                |  |   |   |
|          |      |                                  |   |                                 |                |  |   |   |

NOTE: Date & initial all entries





| ITEM NO. | PART NUMBER | DESCRIPTION         | QTY.<br>-041 |
|----------|-------------|---------------------|--------------|
| 1        | D3798-1     | SPACEPOD FLOOR      | 1            |
| 2        | D3798-3     | SPACEPOD FLOOR FOAM | 1            |

**D3798-041 SPACEPOD FLOOR, LH**

| ITEM NO. | PART NUMBER | DESCRIPTION         | QTY.<br>-042 |
|----------|-------------|---------------------|--------------|
| 1        | D3798-1     | SPACEPOD FLOOR      | 1            |
| 2        | D3798-3     | SPACEPOD FLOOR FOAM | 1            |

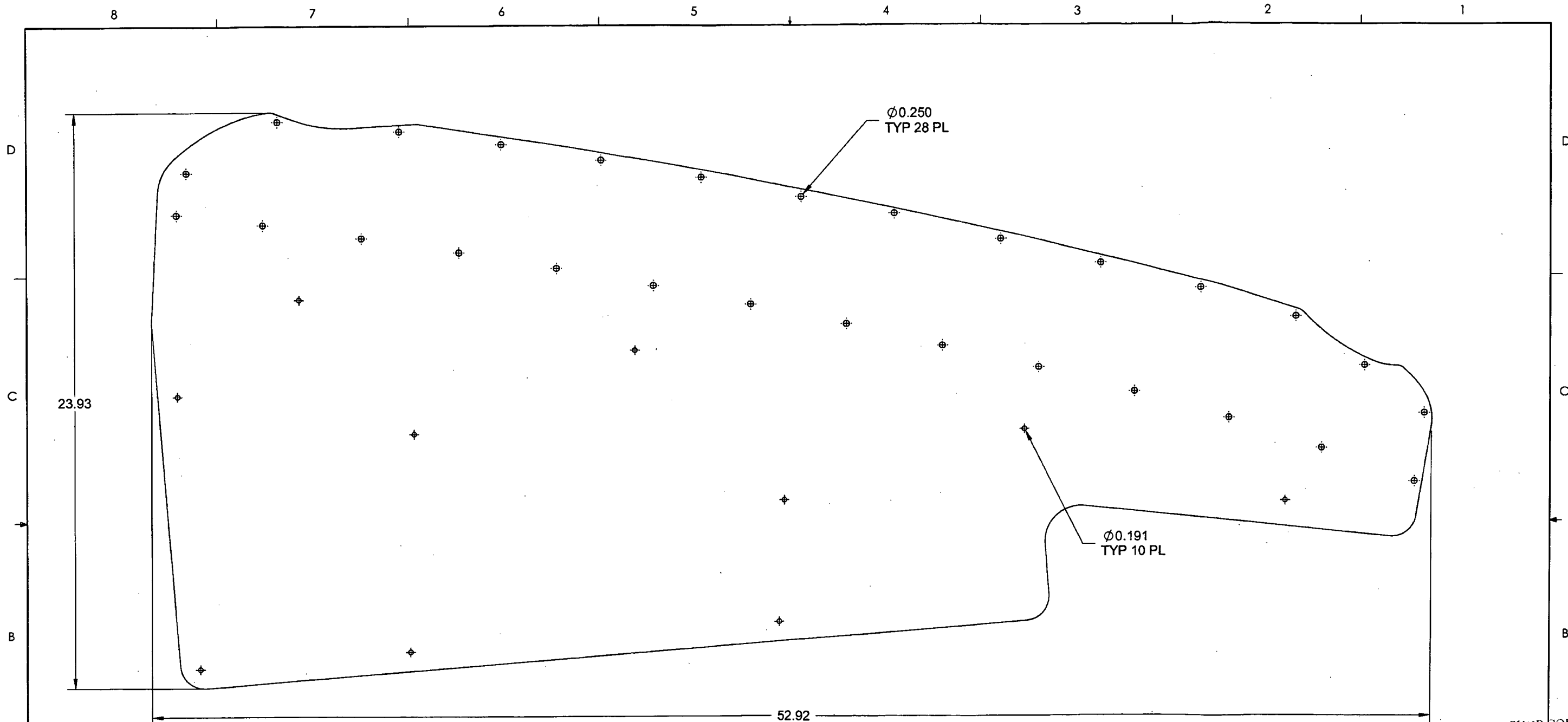
**D3798-042 SPACEPOD FLOOR, RH**

**NOTES:**  
 1) IDENTIFICATION: IDENTIFY WITH DART P/N D3798-041/-042 USING WHITE FINE POINT PERMANENT INK MARKER  
 2) WEIGHT: D3798-041 - 4.5 lbs  
               D3798-042 - 4.5 lbs  
 3) INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT

|            |             |   |              |
|------------|-------------|---|--------------|
| A          | NEW ISSUE   | BY  | 08.10.20     |
| REV.       | DESCRIPTION | BY  | DATE         |
| DESIGN     |             | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      |             |   |              |
| CHECKED    |             | DRAWING NO.   | REV. A       |
| MFG. APPR. |             | D3798   | SHEET 1 OF 3 |
| APPROVED   |             | TITLE   | SCALE        |
| DE APPR.   |             | SPACEPOD FLOOR  | NTS          |
| DATE       | 08.10.20    | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>         THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

**RELEASED**  
 09/01/13 MP

SHIP COPY  
 RETURN TO  
 NO. 45529



**D3798-1 SPACEPOD FLOOR**

**RELEASED**  
09/01/13

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.0 lbs
  - 8) CONTROL PART PER TEMPLATE DT9432

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. A       |
| MFG. APPR. |          | D3798  | SHEET 2 OF 3 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | SPACEPOD FLOOR   | NTS          |
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NO. 48559

